

Work Order ID 64781

Friday, December 17, 2010 7:51:51 AM



Page 1

Item ID: D2654-1

Accept



Setup Start



Revision 'D':

Stop



Item Name: Web

Start Date: 12/16/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-2-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2654

Rev E1

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2654 (73.85") □2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654 □3-Using the uni-bit, open holes to finish size as per Dwg D2654 □4-Deburr holes and ends

6 0 BE 10/2/21

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

6 DP 10-12-22

120

0.00



* Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

6 0 BE 10-12-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64781

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Page 2

Item ID: D2654-1

Accept

Revision ID:

Item Name: Web

Start Date: 12/16/2010 Start Qty: 6.00

Required Date: 1/19/2011 Req'd Qty: 6.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 DP 10-12-22

140

Identify as per dwg & Stock Location LG

0.00



Packaging

Memo

0.00

Packaging

6 Ø BE 10/12/22

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/12/22

10/12/22
6

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, December 17, 2010 7:51:55 AM

Page 1

Work Order ID: 64781

Parent Item: D2654-1

Parent Item Name: Web





Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:D□99.02.04□Fixed typo, Changed procedure□DM
IPP Rev:E 08-06-10 revE1 as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108 		Manufactured	No			100	Each	131.0000	1	6			
Extrusion 'I Beam' thin													

Location

Loc Qty

Loc Code

LG

131

47814

131

6 BE 10/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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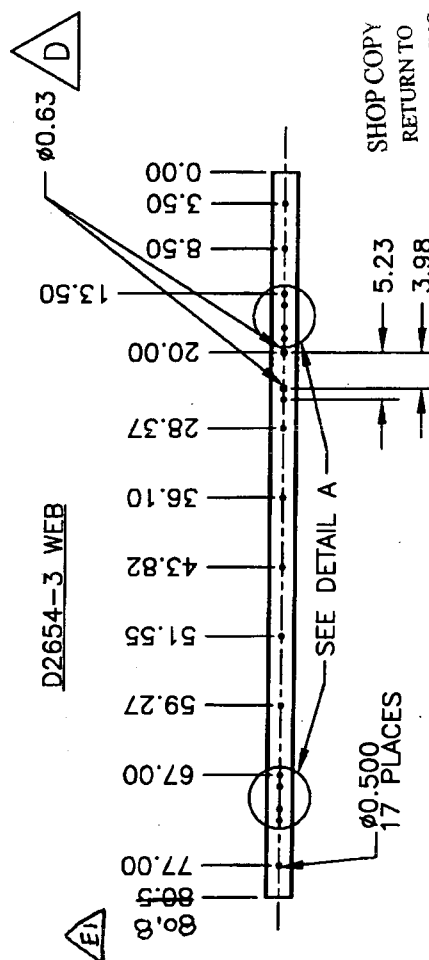
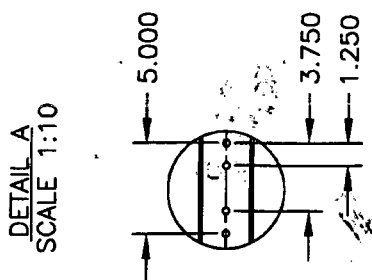
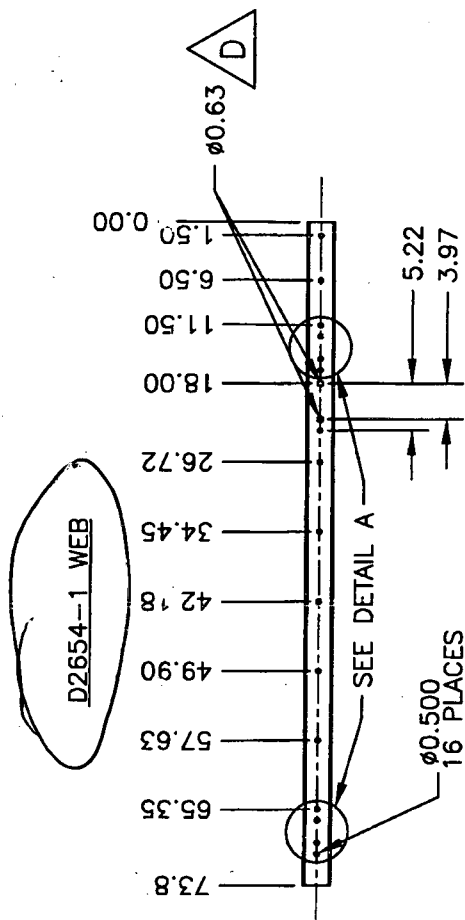
NOTE: Date & initial all entries

DART
DEO ATTACHED



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	#	APPROVED	#	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE	04.05.26			TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE			
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438			
C	97.10.29	CHANGED HOLE PATTERN			
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$			
E	04.05.26	CHANGE LENGTHS, REFORMAT			
E1	CP # 04.08.04	PER TOOLING; 80.8 WAS 80.5			

RELEASED
04.06.22



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MAKE FROM D2600-5-108 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

04/12/10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART

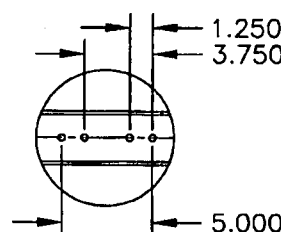


DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	04.05.26	DRAWING NO.	D2654	SHEET 2 OF 2	REV. E
		TITLE	WEB	SCALE	1:20

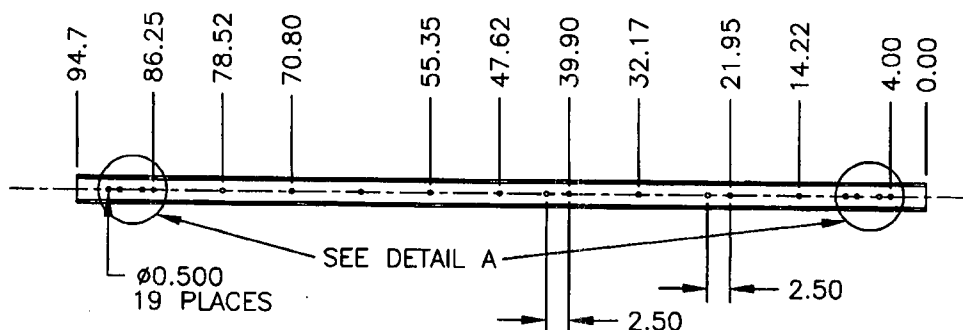
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04.06.22.04

DEO ATTACHED

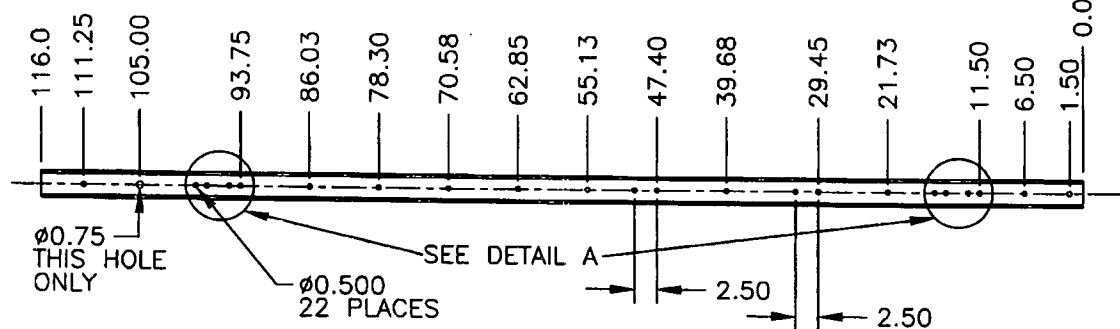
DETAIL A
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



w/o 04781

MAKE FROM D2600-7-125 EXTRUSION
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
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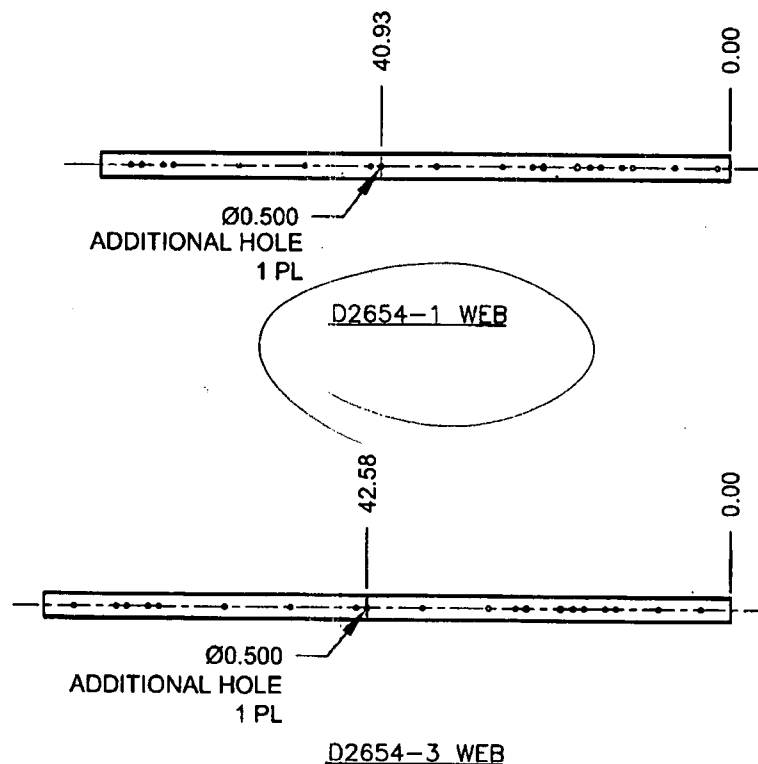
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DRAWING NO. D2654	TITLE WEB	REV. E1	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D2654-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED <i>PH</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>MD</i>		
DATE 09.03.11	DATE 09.03.11	DATE 09.04.03	DATE 09.04.03		DATE 09.04.03		

DRILL AN ADDITIONAL HOLE IN THE D2654-1 AND D2654-3 WEB AT THE LOCATION INDICATED:

RELEASED
09/04/08 *MD*



THE ADDITIONAL HOLE IS REQUIRED FOR COMPATIBILITY WITH D3804-041/-043 SKIDTUBE ASSEMBLIES. ALL OTHER INFORMATION REMAINS UNCHANGED.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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